

Date: Wednesday, 9/20/2006 3:16:30 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |                         |
|-----------------------|---------------------------------------|------------------|-------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : A119 STEP WELDMENT LH |
| Job Number            | : 28654                               |                  |                         |
| Estimate Number       | : 10122                               |                  |                         |
| P.O. Number           | : N/A                                 | Part Number      | : D3043041              |
| This Issue            | : 9/20/2006 S.O. No. : N/A            | Drawing Number   | : D3043 REV A           |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                   |
| First Issue           | : N/A Type : LARGE FAB ASSY           | Drawing Revision | : A                     |
| Previous Run          | : 26197A                              | Material         | : N/A                   |
| Written By            | : <u>                    </u>         | Due Date         | : 9/25/2006             |
| Checked & Approved By | : <u>                    </u>         | Qty:             | 1 Um: Each              |
| Comment               | : Est Rev : A New Issue JLM 05-11-01  |                  |                         |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |           |
|-----|-----------|-----------|
| 1.0 | D2622120C | Extrusion |
|-----|-----------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: D2622-120 extrusion

Batch: 327077

LE. 06.09.21

|     |             |                              |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

327077 LE. 06.09.21

|     |     |                              |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

PD 06-09-21 (1)

|     |       |                   |
|-----|-------|-------------------|
| 4.0 | D2734 | 206 Step Endplate |
|-----|-------|-------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 327281

LE. 06.09.21

|     |        |              |
|-----|--------|--------------|
| 5.0 | D30401 | Mounting Lug |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-1 Mounting Lug 324405

LE. 06.09.21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 28654

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3040-3 Mounting Lug *B 24406*

*P.E. 06-09-21*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802  
AR AL ROD Batch: *M19612 M15689*

*P.E. 06-09-21*

2-Grind Fwd End Cap weld flush

*P.E. 06-09-21*

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*D 06-09-21 (1)*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

*FF 06-09-21*

*CE*  
~~2-Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3~~

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043  
AR AL ROD Batch: *M15689*

*P.E. 06-09-22*

2-Inspect for foreign object as per QSI 024

*P.E. 06-09-22*

3-Grind Fwd End Cap weld flush

*P.E. 06-09-22*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/09/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 28654

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

MA06/09/22 ①

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FL 06 09 22 ①

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06 09 22 ①

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 06-09-23

①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06/09/25 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FL 06/09/25 ①

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 06.09.25

Job Completion



FL 06.09.25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3043                         | REV. A<br>SHEET 1 OF 2 |
| DATE<br>01.06.28              |                                | TITLE<br>A119 STEP WELDMENT                  | SCALE<br>NTS           |
| A                             | 01.06.28                       | NEW ISSUE                                    |                        |

**PARTS LIST:**

| Qty<br>-041 | Qty<br>-043 | Part Number | Description       |
|-------------|-------------|-------------|-------------------|
| X           |             | D3043-041   | STEP WELDMENT, LH |
|             | X           | D3043-042   | STEP WELDMENT, RH |
|             |             |             |                   |
| 1           | 1           | D2622-120   | STEP EXTRUSION    |
| 2           | 2           | D3040-1     | MOUNTING LUG      |
| 2           | 2           | D3040-3     | MOUNTING LUG      |
| 2           | 2           | D2734       | ENDPLATE          |
|             |             |             |                   |

**NOTES:**

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
01.07.05 *[Signature]*

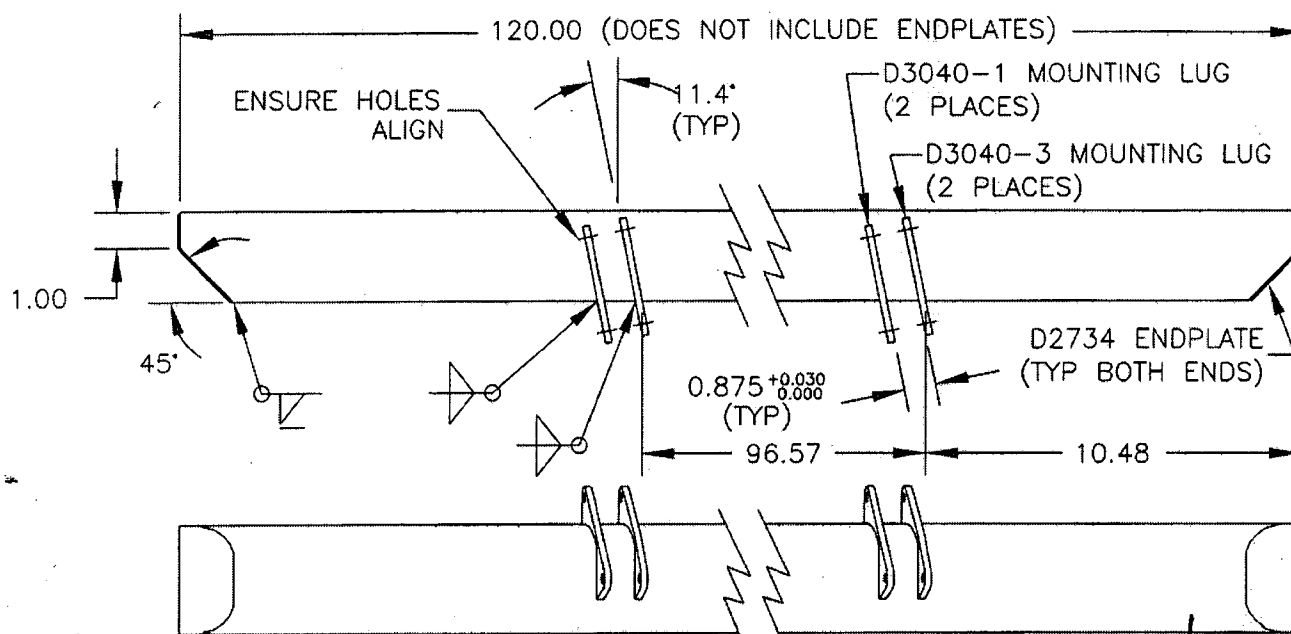
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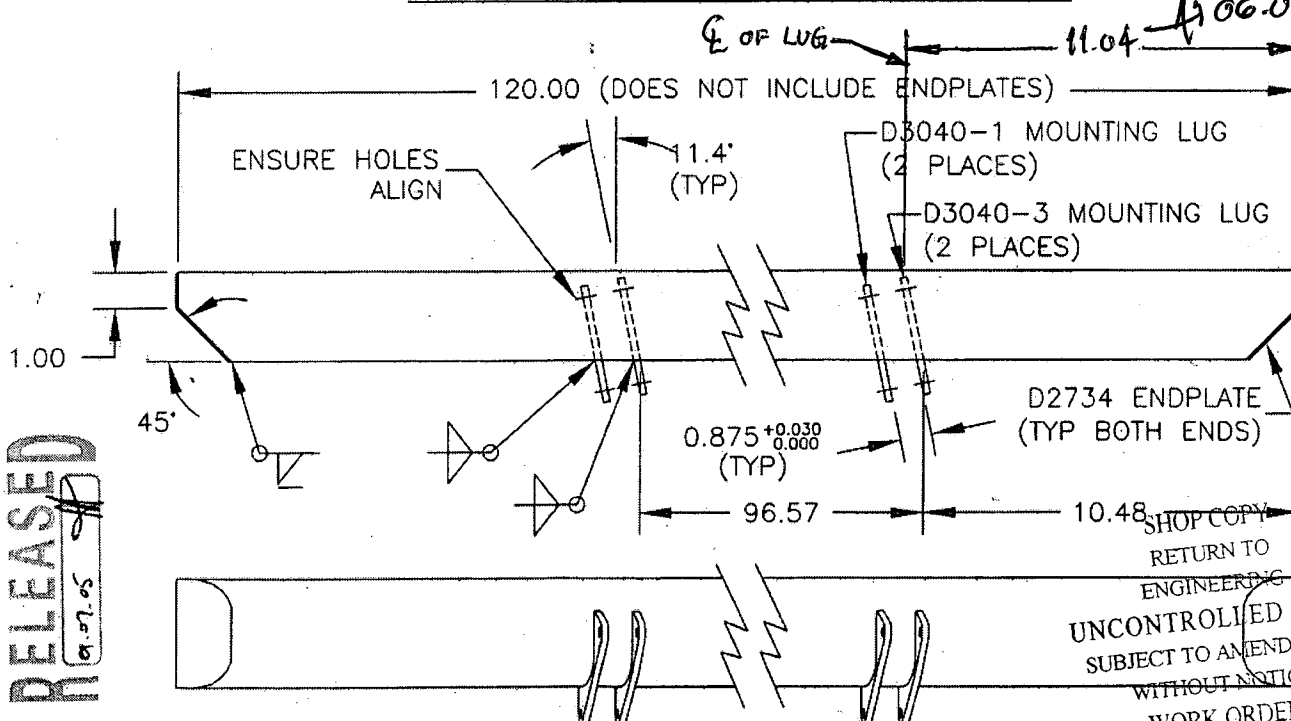
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| CHECKED<br><i>H</i> | APPROVED<br><i>H</i>  | DRAWING NO.<br>D3043                         | REV. A<br>SHEET 2 OF 2 |
| DATE<br>01.06.28    |                       | TITLE<br>A119 STEP WELDMENT                  | SCALE<br>1:5           |
| A                   | 01.06.28              | NEW ISSUE                                    |                        |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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